

Work Order ID 153271

Tuesday, November 15, 2016 11:17:55 AM

153271

PRELIMINARY ISSUE

Page 1

Item ID: 647.7333

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lower Cutter Removable Provisions

Stop

NS2

Start Date: 12/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

VS

Date: 12/14/16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7333								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

SHIP DEC 9TH

POSITIVE
RECALL

DAS
21
9-89

DAS
6
9-89

DAS
21
9-89

DAS
28
9-89

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 153271

Tuesday, November 15, 2016 11:17:55 AM

153271

Page 2

Item ID: 647.7333

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lower Cutter Removable Provisions

Start Date: 12/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP 647.7333
Location : FG109DAS
27
9-89DAS
28
9-89

DEC 19 2016

140

0.00

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

DAS
21
9-89

DEC 20 2016

POSITIVE RECALL

EFFECTIVE 11-16-16

AUTH

RELEASED

DATE

RD 16 1006-01

DAS
21
9-89

DEC 20 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER :			
Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

Tuesday, November 15, 2016 11:17:55 AM

Page 1

Work Order ID: 153271

153271

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.09.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
601.3902 *601 3902* Eye Bolt		Manufactured	No				Each	1.0000		1			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ckk101			1					
					147212			1					
647.7501 *647 7501* Lower Cutter Assembly		Manufactured	No				Each	0.0000		1			
									**				
647.7702 *647 7702* Strut Assembly		Manufactured	No				Each	3.0000		2			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					CCK076			3					
					146723			3					
647.0112 *647 0112* Strut Bracket		Manufactured	No				Each	79.0000		2			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					CCK107			54					
					150114			42					
					151352			12					
					CCK108A			25					
					150895			15					
					151894			10					

DAS
28
9-89

DAS
6
9-89
DEC 1 9 2016
DAS
27
9-89

DAS
27
9-89

DAS
6
9-89
DEC 1 5 2016
DAS
27
9-89

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, November 15, 2016 11:17:55 AM

Page 2

Work Order ID: 153271

153271

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN44-5A Purchased No Each 27.0000

AN44-5A

Eyebolt

**

2

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

ST339

27

m135127

3

m135774

12

m136047

12

153853

DAS
27
9-89
6
9-89

AN665-34R Purchased No Each 23.0000

AN665-34R

Clevis

**

2

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

ST330

23

M135603

3

M135948

20

2

DAS
27
9-89
6
9-89

AN3-11A Purchased No Each 96.0000

AN3-11A

Bolt

**

2

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

ST349

96

m135390

2

m135767

94

2

DAS
27
9-89
6
9-89

AN4C7A Purchased No Each 96.0000

AN4C7A

BOLT

**

2

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

OVER002

70

m135864

70

ST345

26

m135470

26

2

DAS
27
9-89
6
9-89

Tuesday, November 15, 2016 11:17:55 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Picklist Print

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Page 3

Work Order ID: 153271

153271

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS6603-12 Purchased No

Each 136.0000

NAS6603-12

Bolt

**

DEC 15 2016

DAS 27 9-89
DAS 6 9-89

Location

Loc Qty

Loc Code

st552

136

124

12

123900

m130388

9

NAS6603-16 Purchased No

Each 81.0000

NAS6603-16

Bolt

**

DEC 15 2016

DAS 27 9-89
DAS 6 9-89

Location

Loc Qty

Loc Code

st552

81

19

12

50

m128199

m130388

m133523

133860

MS21042-08 MS21042L08 Purchased No

Each 0.0000

MS21042-08

USE MS21042L08

**

DEC 15 2016

DAS 27 9-89
DAS 6 9-89

MS21042-3 MS21042L3 Purchased No

Each 0.0000

MS21042-3

Nut

**

DEC 15 2016

DAS 27 9-89
DAS 6 9-89

DAS 28 9-89

Tuesday, November 15, 2016 11:17:55 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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153271

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

1,964.000

2

MS21042L4

**

Nut

DEC 15 2016

DAS 27
6 9-89
9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

204

m135058

204

OVER007

500

m135979

500

ST303

1226

m135774

226

m135864

1000

2

AN316C4R

Purchased

No

Each

13.0000

2

AN316C4R

**

Nut, Jam

DEC 15 2016

DAS 27
6 9-89
9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

ST331

13

m135840

13

136/92

MS27039-08-13

Purchased

No

Each

72.0000

2

MS27039-08-13

**

Screw

DEC 15 2016

DAS 27
9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

ST278

72

124326

72

2

DAS 6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Picklist Print

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Work Order ID: 153271

153271

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

1,463.000

4

NAS1149FN832P

Washer

**

DAS
6
9-89

DAS
27
9-89

DEC 15 2016

Location

Loc Qty

Loc Code

GA

1285

M135058

1285

ST263

178

M135603

178

Each

1,167.000

**

DAS
6
9-89

DAS
27
9-89

DEC 15 2016

NAS1149C0432R

Purchased

No

Each

1,167.000

NAS1149C0432R

WASHER

**

DAS
6
9-89

DAS
27
9-89

DEC 15 2016

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST266

794

m135979

794

Each

1,641.000

**

DAS
6
9-89

DAS
27
9-89

DEC 15 2016

NAS1149F0532P

Purchased

No

Each

1,641.000

NAS1149F0532P

Washer

**

DAS
6
9-89

DAS
27
9-89

DEC 15 2016

Location

Loc Qty

Loc Code

ST260a

600

m133725

600

ST262

1041

18057

1041

Tuesday, November 15, 2016 11:17:55 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 15: Universal Wiper Deflector (WD) Assembly, 647.7341

FIND #	PART #	DESCRIPTION	QTY
4	647.1601	WIPER DEFLECTOR ASSY, AFT	1
5	647.1610	WIPER DEFLECTOR, FWD	1
29	647.1914	BRACKET	1
30	647.1602	DOUBLER ASSY	1
35	647.3201	GROUNDING CABLE ASSY	1
47	601.1324	BOLT	1
52	601.2973	LOCKNUT	1
53	601.2943	LOCKNUT	3
60	601.2525	SCREW	1
63	601.2198	SCREW	3
67	601.1622	SCREW	4
72	601.2999	SCREW	3
85	601.2764	WASHER	2
86	601.1607	WASHER	10
89	601.2375	WASHER	3

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WORK ORDER
NO. 153271
ADK

DEC 16 2016



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

REFERENCE ONLY

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 12: T1/P1 LC Removable Provisions Kit, 647.7333

FIND #	PART #	DESCRIPTION	QTY
2	647.7501	LOWER CUTTER ASSY	1
10	647.7702	STRUT ASSY	2
14	647.0112	STRUT BRACKET	2
38	601.3121	EYE BOLT AN44-5A	2
40	601.3119	CLEVIS AN665-34R	2
46	601.2826	BOLT AN3-11A	2
48	601.2669	BOLT AN4C7A	2
49	601.1500	BOLT NA56603-12	4
50	601.3130	BOLT NA56603-16	4
52	601.2973	LOCKNUT M521042-08	2
53	601.2943	LOCKNUT M521042-3	2
54	601.3209	LOCKNUT M521042L4	2
55	601.3128	NUT AN316C4R	2
61	601.2988	SCREW M527039-08-13	2
85	601.2764	WASHER NA51149FN832P	4
87	601.3663	WASHER NA51149CO432P	4
88	601.3126	WASHER NA51149FO532P	2

Work Order ID 153271

Friday, December 16, 2016 10:22:32 AM

153271

Page 1

Item ID: 647.7333

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: EC135 T1/P1 Lower Cutter Removable Provisions

Start Date: 12/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

MPP-195

N/C

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP 647.7333

DAS
21
9-89

DEC 16 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Marie Lajeunesse

From: Kim Johnston
Sent: Friday, December 16, 2016 9:51 AM
To: Marie Lajeunesse
Subject: FW: EC135 CCK MPP & IIN corrections

Thanks,

Kim Johnston
Engineering Clerk
Document Administrator

DART AEROSPACE
T 1 613 632-5200 > ext. 226
F 1 613 632-9311



From: Sian Willems
Sent: Monday, December 12, 2016 9:21 AM
To: Lisa McMachen <lmcmachen@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: EC135 CCK MPP & IIN corrections

Go ahead and load. A corrected version will follow once DaveM makes the updates.

SIAN WILLEMS
Customer Support Manager

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From: Lisa McMachen
Sent: Monday, December 12, 2016 8:26 AM
To: Kim Johnston <kjohnston@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: EC135 CCK MPP & IIN corrections

Hi Sian,
Kim says that the paperwork is not jiving...can we load the attached documents to the website as discussed on Friday? Please see the attached email.

Thanks,
Lisa McMachen

From: Sian Willems
Sent: Monday, December 12, 2016 7:21 AM